

Work Order ID 52265

September 22, 2009 8:26:14 AM



Page 1

Item ID: D3140-95

Accept



Setup Start



Revision ID: F

Stop



Item Name: Doubler

Start Date: 9/22/09 Start Qty: 4.00



Cust Item ID:

Required Date: 9/25/09 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: CL

Date: 09/09/2009 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3140

Rev F

100

0.00



SHEAR

Shear

Memo

0.00

Shear

Cut as per dwg D3140

M. L 09/09/29



110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Scuff surfaces with 80grit sandpaper per QSI 006 2-Deburr. No sharp edges

M. L 09/09/29

M. L 09/09/30

EB 09/09/30



120

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Bend as per Dwg D3140

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52265

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Page 2

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Required Date: 9/25/09 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

3) 501/01/30

0.00

(X11)

/

QC

Memo

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

1/1 04-10-01

0.00

Q.

HandFinish

Memo

Hand Finishing

150

QC3- Inspect Part Finish

0.00

1/1 09/10/01

0.00

(X11) /

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
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Start Date: 9/22/09 Start Qty: 4.00

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 66P

0.00



Packaging

Memo

0.00

Packaging

9/10/01, 110 SP

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/01 JF
MF 09-10-01

Picklist Print

September 22, 2009 8:26:13 AM

Page 1

Work Order ID: 52265

Parent Item: D3140-95RevF

Parent Item Name: Doubler

Comments:



Start Date: 9/22/09

Required Date: 9/25/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	94.2179	0.6211			
2024-T3 .032 sheet												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

94.21793158

102942

1.5

105555

4.0684

106272

5.3

108595

3

109240

7.02

110778

23.9106316

111699

46.4189

18147

3

M-10 09/29/09

M108595

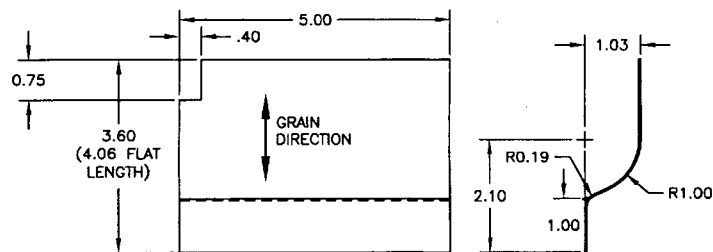
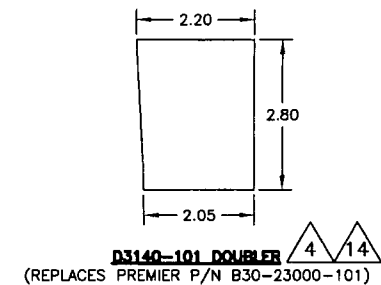
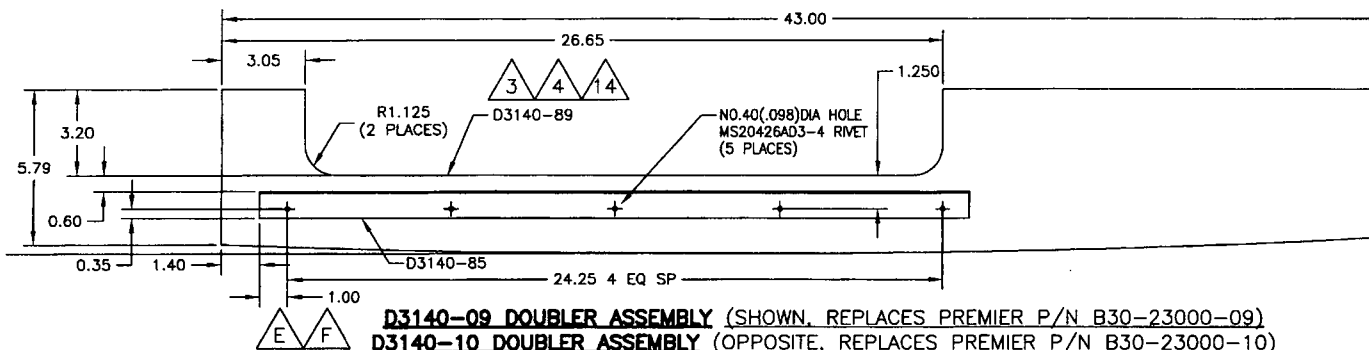
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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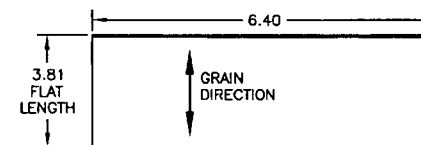
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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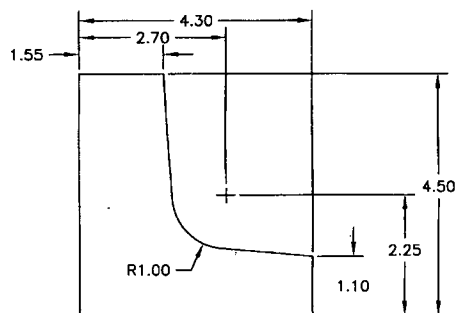
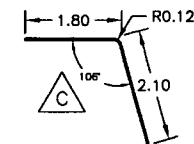


D3140-91F FLAT PATTERN
(USE TO MAKE D3140-91/-92 DOUBLERS)

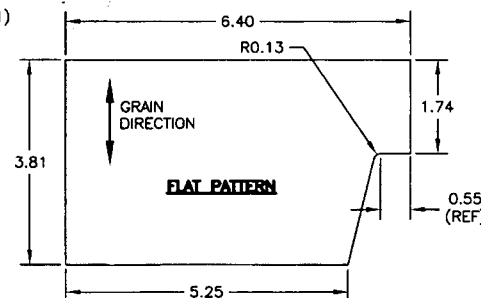
D3140-92 DOUBLER (SHOWN, REPLACES PREMIER P/N B30-23000-92)
D3140-91 DOUBLER (OPPOSITE, REPLACES PREMIER P/N B30-23000-91)



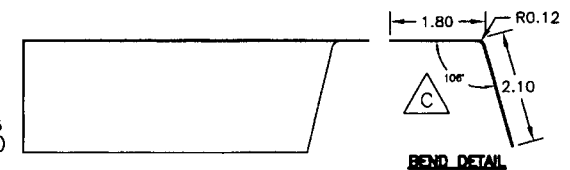
D3140-95 DOUBLER
(REPLACES PREMIER P/N B30-23000-95)



D3140-99 DOUBLER
(REPLACES PREMIER P/N B30-23000-99)



D3140-97F FLAT PATTERN
(USE TO MAKE D3140-97/-98 DOUBLERS)



D3140-97 DOUBLER (SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

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DESIGN #	DRAWN BY CB	DART	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED JH	APPROVED JH	DRAWING NO. D3140	REV. F SHEET 5 OF 7
DATE 06.10.06	TITLE DOOR	SCALE NTS	